Work Order ID 71846

Wednesday, July 13, 2011 10:21:39 AM

Page 1

Item ID:

D3493-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name: Washer

Required Date: 7/28/2011

7/14/2011

Start Qty: 40.00 Req'd Oty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MC

Date: 11-07-13 Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

QC:

D3493 Rev A

100

Hardinge

Hardinge CNC LATHE SMALL Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA626 & Dwg D3493 2-Deburn

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

118116

120

110

QC8- Inspect parts - second check

0.00

Memo

Rep 11. 8 - 16

Quality Control

W/O:	•		W	ORK ORDER CHANG	ES					<u> </u>
DATE	STEP	PROC	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										·
Part No		PAR #:								
NOD	n'	esolution:		ER NON-CONFORMA					Date: _	·
NCR:	T					. (1101	• <i>)</i>			T
DATE	STEP	Description of NC Section A	Initial Action Description Chief Eng Chief Eng		ion B	Sign 8	Verific Secti		Approval Chief Eng	Approval QC inspector

Work Order ID 71846

Wednesday, July 13, 2011 10:21:39 AM



Page 2

Item ID:

D3493-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Washer

7/14/2011

Start Qty: 40.00 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Process Plan: _____

Date:

Tooling:

Date:

Run Start

Approvals:

Required Date: 7/28/2011

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

QC: ____

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject

Reject Insp. Mumber Stamp

Memo

Memo

0.00

140

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

W/O:			WC	RK ORDER CHANG	SES		·· –		
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			<u> </u>
DATE	STEP	Description of NC Section A Initial Action Description			Veri			Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Dat		ion C	Chief Eng	QC inspector
		1							

Picklist Print

Wednesday, July 13, 2011 10:21:36 AM

Work Order ID: 71846

Parent Item:

D3493-1

Parent Item Name: Washer



Start Date: 7/14/2011

Required Date: 7/28/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev: A New Issue 06-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			100	f	62.8500	0.0291	1.225263	1,15	8 116	

304 round bar 1.00

Location	Loc Qty	Loc Code
MAT029	62.85	
109508	12.5	
109541	2.18	
H18457	48.17	

	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			<u></u>						
									,
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A :	Date: _	<u>.</u>
Resolution:			Disposition: Q			losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)		^	
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
	,								

DART AEROSPACE LTD	Work Order: 71846
Description: Washer	Part Number: D3493-1
Inspection Dwg: D3493 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Article	F	Prototyp	е	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
0.192	+0 000/-0 005	19/			V 3	Γ

Dimension	loierance	Dimension	Accept	Reject	Inspection	Comments
0.192	+0.000/-0.005	191		-	P-16	
Ø1.000	+/-0.010	35	//			
Ø0.958 x 100°	+/-0.010	9601108				
Ø0.516	+0.008/-0.001	.521				
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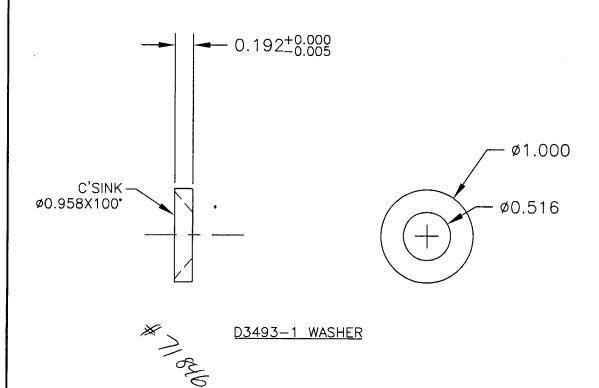
	'\						
Measured by:	2		Audited by:	29		Prototype Approval:	N/A
Date:	10	8/16	Date:	11.8.	16	Date:	N/A

Rev	Date	Change	Revised by Approv
A	06.09.01	New Issue	KJ/JLM
В	06.11.22	Ø0.516 dimension removed	KJ/JLM
С	08.04.30	Dimensions updated	KJ/DD X

W/O:			N	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	•								
					<u> </u>				
		•			1:				
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA	۱:	Date:	
	Re	esolution:	Disposit	ion:	QA: N/C C	osed:		Date:	
NCR:		ं	WORK OR	DER NON-CONFORMA	NCE (NCF	?)			
		Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
-				Action Description Chief English		·	, ,		· ·
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DESIGN	PH	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKE	7	APPROVED #	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE			TITLE	SCALE
06.01	.04		WASHER	1:1
A		06.01.04	NFW ISSI	JF



D3493-1 WASHER

- MATERIAL: AISI 304/316 STAINLESS STEEL Ø1.000 ROUND BAR (REF DART MATERIAL SPEC M304R1.000)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX



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W/O:			WC	RK ORDER CHANGE	S		<u> </u>		
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:				
	Re	esolution:	Disposition	QA: N/C CI	N/C Closed: Date:				
NCR:		\	WORK ORDI	ER NON-CONFORMAN	ICE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section			Verification		Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
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